











Work Order ID 56466

Wednesday, February 24, 2010 11:49:32 AM

Page 1

Item ID:	D2873-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Nut Plate Assembly				Stop	
Start Date:	2/25/2010	Start Qty:	20.00		Cust Item ID:	
Required Date:	3/10/2010	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-2-24</u>	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 3.700" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev <u>A</u> Folio Rev <u>AA</u>								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

ml 10/02/24

20 0

SP 10/02/25

20 0

SP 10/02/25

20 0

Work Order ID 56466

Wednesday, February 24, 2010 11:49:32 AM

Page 2

Item ID: D2873-043

Accept

Setup Start

Revision ID:

Item Name: Nut Plate Assembly

Stop

Start Date: 2/25/2010 Start Qty: 20.00

Cust Item ID:

Required Date: 3/10/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

St 10/02/25



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

8/5/10/03/02 (20)

150

QC5- Inspect part completeness to step on W/O

0.00

S. 10/03/02



QC

Memo

0.00

Quality Control

counters
(420)

Work Order ID 56466

Wednesday, February 24, 2010 11:49:32 AM

Page 3

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Start Date: 2/25/2010 Start Qty: 20.00

Required Date: 3/10/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MS 10/03/04 x

(20)

/

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-03-14

(20)

/

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 02-Identify as D2873-043

10/03/04

Work Order ID 56466

Wednesday, February 24, 2010 11:49:33 AM

Page 4

Item ID: D2873-043

Accept

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Start Date: 2/25/2010 Start Qty: 20.00

Required Date: 3/10/2010 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.03/04

(420)

200

Identify as per dwg & Stock Location: x-tube

0.00



Packaging

Memo

0.00

Packaging

ml

10

03

08

(20)

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11

MF

10-38

Picklist Print

Wednesday, February 24, 2010 11:49:32 AM

Page 1

Work Order ID: 56466

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 2/25/2010

Required Date: 3/10/2010

Comments: IPP A 05.09.13 New issue KJ/JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	17.3358	6.4905			



6061T6 BAR .375 x 1.00

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

17.33578948

105225

5.3

110829

2.83578948

→ 113325

9.2

MS20426AD4-6

Purchased

No

180

Each

3,573.000

120.0000



Rivet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3573

100151

27

103395

14

110139

3505

2525

27

6.4905 m 10/02/24

10/03/04

120

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 24, 2010 11:49:32 AM

Page 2

Work Order ID: 56466



Parent Item: D2873-043



Parent Item Name: Nut Plate Assembly

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Required Date: 3/10/2010

Comments: IPP A 05.09.13 New issue KJ/JLM

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21075L5

Purchased

No

100

Each

270.0000

60.0000



Nut Plate

EF 5/10/03/04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

270

110916

79

112243

191

60

Wednesday, February 24, 2010 11:49:32 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56466
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

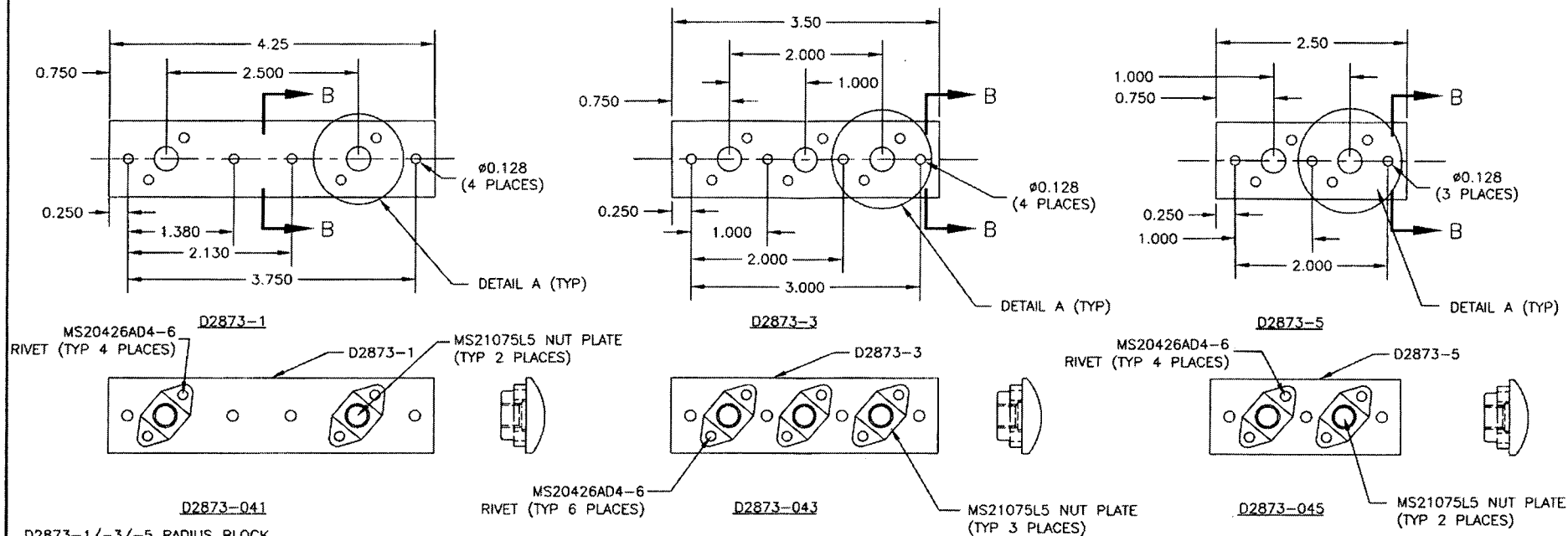
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.503	✓			
2.000	+/-0.010	2.001	✓			
0.750	+/-0.010	.748	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.249	✓			
1.000	+/-0.010	.998	✓			
2.000	+/-0.010	1.998	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	.132	✓			
0.359	+/-0.010	.361				
Ø0.316	+0.006/-0.001	.318	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	.246	✓			
0.061	+/-0.010	.063	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.232 x .123	✓			

Measured by:	L.P.	Audited by:	JL	Prototype Approval:	N/A
Date:	10/02/25	Date:	10/02/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>



D2873-1/-3/-5 RADIUS BLOCK

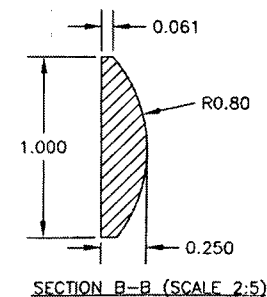
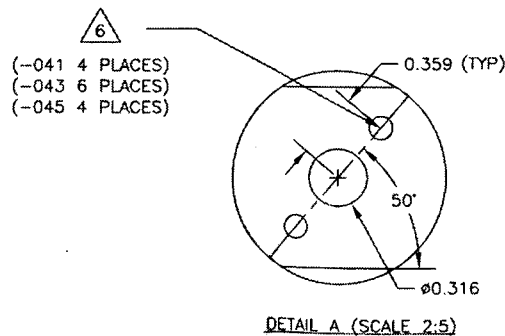
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) $\varnothing 0.128$ PILOT + C'BORE CURVED SIDE $\varnothing 0.230 \times 0.125$ DEEP + C'SINK CURVED SIDE $\varnothing 0.225 \times 100^\circ$

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	DS	APPROVED DS
DATE	05.07.26	TITLE
		RADIUS BLOCK